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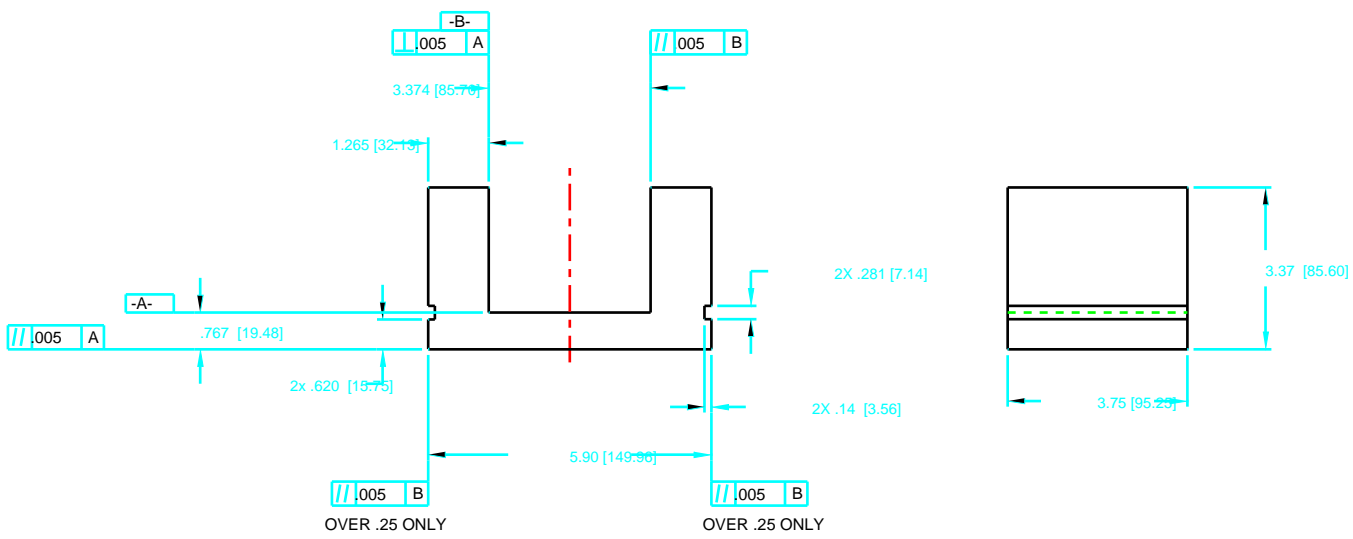
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NOTES:

1. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
2. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
3. ALL SURFACES MUST BE MACHINED FOR CLEAN UP
4. TUNGSTEN ALLOY OF 95% TUNGSTEN OR MORE WITH REMAINDER OF NICKEL AND IRON PER MIL-T-21014D, CLASS 3, UHV GRADE
5. FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
6. CLEANING: THE COMPONENT MUST BE CLEANED SUCH THAT A UHV PRESSURE OF 1×10^{-9} TORR CAN BE ACHIEVED
7. HANDLING: THE COMPONENTS SHALL BE HANDLED WITH WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM FOIL TYPE DRY ANNEAL AND UNDER CLEAN ROOM CONDITIONS
8. BREAK ALL SHARP CORNERS .010
9. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY
10. SURFACE ROUGHNESS $63 \sqrt{}$

REF. SOURCE

- KULITE TUNGSTEN CORP.
160 EAST UNION AVENUE
EAST RUTHERFORD, NJ 07073 OR
TEL: 1-201-438-9000
FAX: 1-201-438-0891
- MITEK METALS INC.
1340 NORTH SENATE AVENUE
INDIANAPOLIS, IN 46202
TEL: 1-317-637-3574
FAX: 1-633-7224

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
UNLESS OTHERWISE SPECIFIED, LOG NUMBER				
ALL DIMENSIONS ARE IN INCHES				
TOLERANCES				
DECIMALS ANGULAR				
.01 (2.5) .010				
.001 (0.25) .001				
.0005 (0.13) .0005				
SURFACE ROUGHNESS 125				
REMOVE ALL BURRS AND BREAK SHARP EDGES .02 MAX.				
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST AND BEST PRACTICE				
SUBMITTING & TOLERANCING IN ACCORDANCE WITH LATEST AND BEST PRACTICE				
NO NET SCALE DRAWING				
PARTS LIST				
THIS DRAWING IS THE PROPERTY OF				
ARGONNE NATIONAL LABORATORY				
ADVANCED PHOTON SOURCE				
S3-30 I.D. SAFETY SHUTTER				
TUNGSTEN BLOCK				
MIDDLE LOWER SHUTTER				
SCALE HALF				
SHEET 11				
C				
DRAWING NUMBER				
S3-320002-00				